

Work Order ID 85045

85045

Page 1

May-31-12 3:40:26 PM

Item ID: D4110-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Doubler. RH

Start Date: 31/05/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/01*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4110

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg ***make from D4110-1***

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10

1812-6-18

1812-6-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item Name: Door Doubler, RH

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Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Sizel

(10)

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

10x

12/06/20

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Sizel

(10)

Quality Control

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Page 3

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Revision ID:

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5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: 097

0.00

150

Packaging

Memo

0.00

Packaging

10

12/06/2020

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/06/21 JJ

mcj 12/06/20

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Picklist Print

May-31-12 3:40:30 PM

Page 1

Work Order ID: 85045

85045

Parent Item: D4110-2

D4110-2

Parent Item Name: Door Doubler, RH

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	271.4720	0.0318	0.167368			

M304S16GA

304/316 Sheet .063

**

19

B2-C-18

Location

Loc Qty

Loc Code

MAT020

271.472

121626

143.972

121889

127.5

121889

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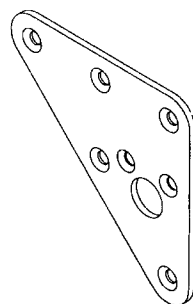
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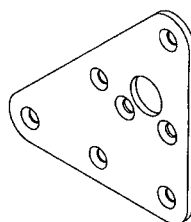
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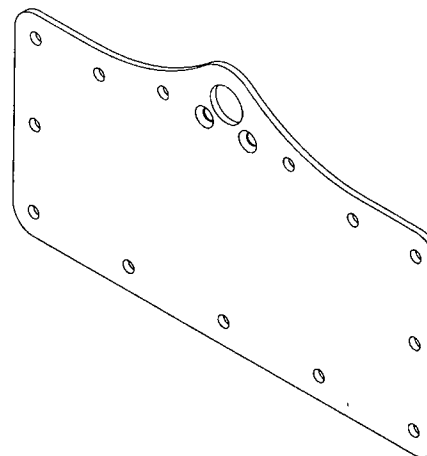
NOTE: Date & initial all entries



D4110-1 DOUBLER, LH DOOR



D4110-2 DOUBLER, RH DOOR



D4110-3 DOUBLER, SILL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85045 ALC

12/06/01

RELEASED
2010-09-23
and

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4110	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
DATE	10.07.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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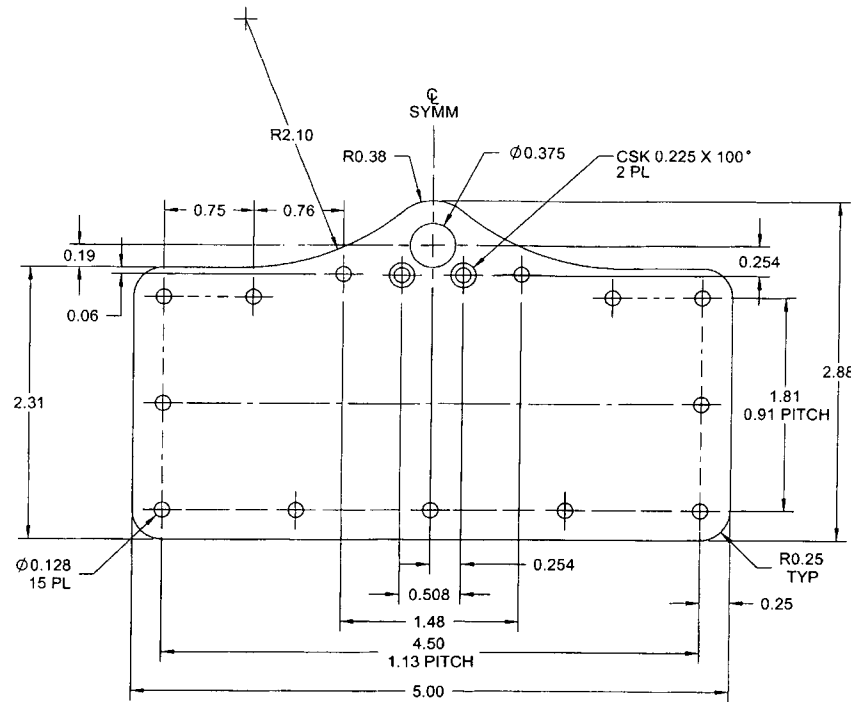
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25.045



D4110-3 DOUBLER, SILL

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

RELEASED
2010-09-23

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4110	REV. A
MFG. APPR.	JPH	SHEET 3 OF 3	
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLER	NTS
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